



W/O: 76250-1

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2893-1

PAR #: \_\_\_\_\_

Fault Category: MachiningNCR: Yes NoDQA: NotDate: 11/11/29Resolution: ScrapDisposition: ScrapQA: N/C Closed: ckDate: 11/11/30NCR: 11-1018

## WORK ORDER NON-CONFORMANCE (NCR)

235.78 x 2 = 451.56

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/22	100	Support gussets undercut. 4 axis parameter set wrong. P.L. operator forgot to save setting L0A	<u>[Signature]</u> 11/23/11 P51042	-Scrap + Dstry qty x2 (1 set) No Replace <del>and not enough</del> Blanks to Replac <u>Replaced</u> <u>66</u> 11/11/23	<u>[Signature]</u> 11/11/23	<u>and</u> 11/11/23	<u>[Signature]</u> 11/23/11 P51042	<u>S</u> 11/11/23

NOTE: Date &amp; initial all entries

# Work Order ID 76250

**\*76250\***

Page 2

Item ID: D2893-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: 2.75 Support

Start Date: 08/11/2011 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 08/12/2011 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00

**\*130\***

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

*AS* 11 - 11 - 23 (8)

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

(8) B 11-11-23

170

Identify as per dwg & Stock Location: *X-tube*

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

*Ass'y*

*AS* 11 11-24 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 76250

**\*76250\***


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November-08-11 7:44:49 AM

Item ID: D2893-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 2.75 Support  
 Start Date: 08/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 08/12/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

11/11/24 

MF 11-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-08-11 7:44:53 AM

Page 1

Work Order ID: 76250

\*76250\*

Parent Item: D2893-1

\*D2893-1\*

Parent Item Name: 2.75 Support

Start Date: 08/11/2011

Required Date: 08/12/2011

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP: C02.11.26Reformat; Added P/OKJ  
 IPP D 06.04.19 removed alodine EC  
 IPP Rev:E Added priming as per Rev B 07-04-30 JLM  
 IPP F 08.03.19 Re-format EC verified by: DD  
 IPP Rev:G 08-05-15 add QC14 DD verified by:EC  
 11.08.04 as per dwg rev.C DD verf:EC  
 IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	3.0000	0.5	10.52632			

\*DSK078\*

\*\*

D2893-1 TURNING DETAIL

26 11/1/25

## Location

## Loc Qty

## Loc Code

MAT060

3

69591

1

70242

2

76060

1

2

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 76250
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.997	2.997	2.997	2.997	2.995
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.128	.128	.128	.128	.128
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.142	.142	.142	.142	.142
AG	0.140	0.160		.148	.148	.148	.148	.148
AH	1.360	1.400		1.382	1.380	1.382	1.382	1.375
AI	0.040	0.060		.053	.053	.053	.053	.053
AJ	1.190	1.230		1.225	1.225	1.225	1.225	1.222
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.06	.06	.06	.06	.06
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.528	2.528	2.528	2.528
AO	84.39	90.39	DT 8699	✓	✓	✓	✓	✓
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.060	.060	.060	.060	.060
AR								
AS								
AT								
Accept/Reject								

Measured by: BC / SA Date: 11/11/22

Audited by: amz Date: 11/11/23

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<u>[Signature]</u>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 76250
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995		
AB	0.440	0.460		.450	.450	.450		
AC	0.125	0.160		.128	.128	.128		
AD	0.040	0.060		.050	.050	.050		
AE	0.188	0.193		.188	.188	.188		
AF	0.125	0.160		.142	.142	.142		
AG	0.140	0.160		.148	.148	.148		
AH	1.360	1.400		1.375	1.375	1.375		
AI	0.040	0.060		.053	.053	.053		
AJ	1.190	1.230		1.222	1.222	1.222		
AK	0.010	0.020		.010	.010	.010		
AL	0.053	0.073		.060	.060	.060		
AM	0.240	0.260		.250	.250	.250		
AN	2.518	2.538		2.528	2.528	2.528		
AO	84.39	90.39	DT 8699	✓	✓	✓		
AP	0.261	0.266		.261	.261	.261		
AQ	0.053	0.073		.060	.060	.060		
AR								
AS								
AT								
Accept/Reject								

Measured by: BC / SA Date: 11/11/23

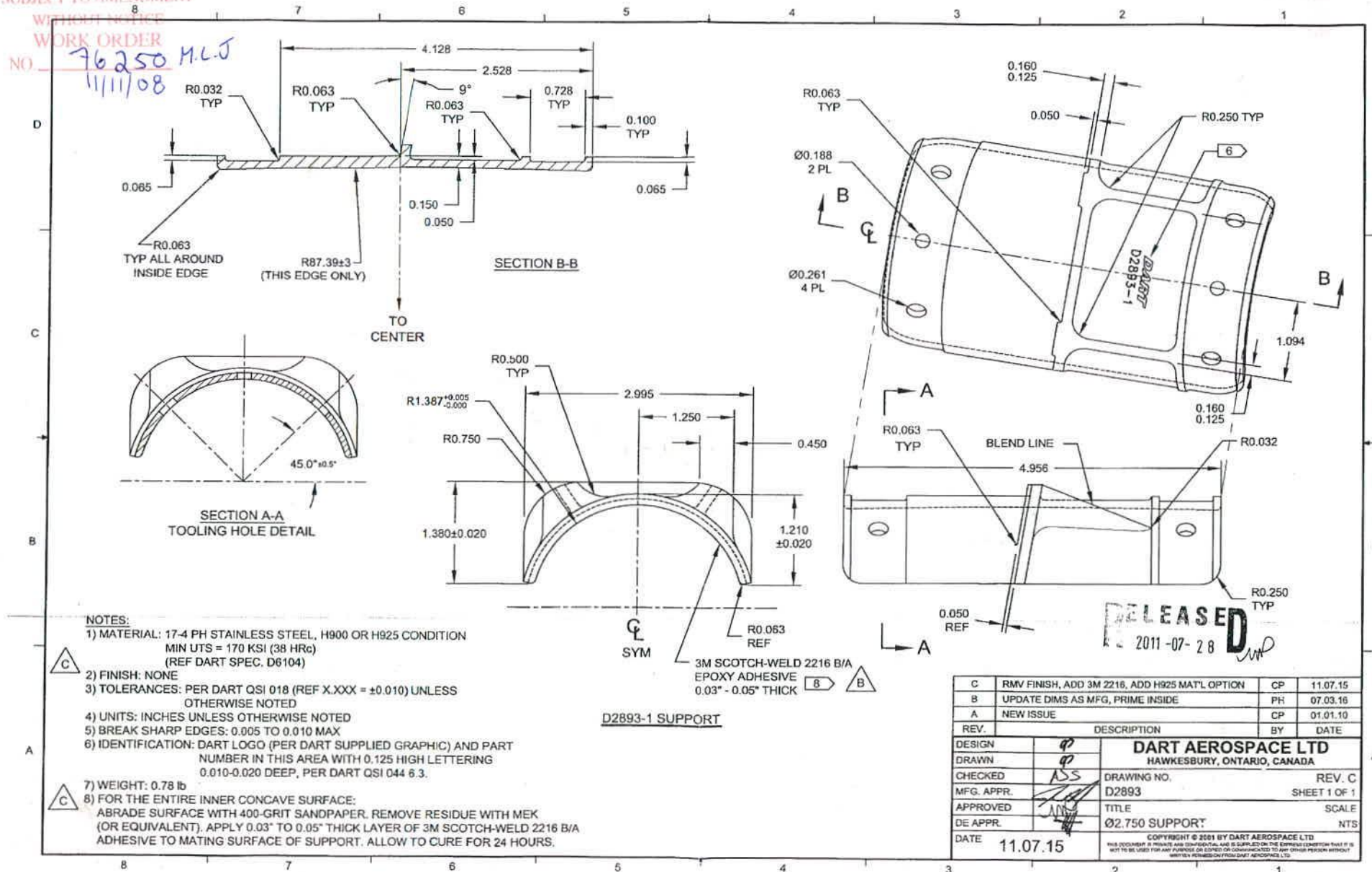
Audited by: SMX Date: 11/11/23

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	



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**NOTE:** Date & initial all entries